

Work Order ID 82203

Saturday, March 24, 2012 1:09:00 PM

82203

Page 1

Item ID: D4610-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 3/26/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MUCDate: 03-24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4610

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4610

Dwg Rev: AProg Rev: A

2-Deburr as required

FB12-3-25

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

FB12-3-25

Work Order ID 82203

82203

Page 2

Saturday, March 24, 2012 1:09:00 PM

Item ID: D4610-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 3/26/2012 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									

82203/26

12

12 BL 123-26

12 d M 2/03/26

Work Order ID 82203***82203***

Page 3

Saturday, March 24, 2012 1:09:00 PM

Item ID: D4610-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 3/26/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location 203	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/3/27 SP (130)

12/3/28 JF
MF
12-03-27

Picklist Print

Saturday, March 24, 2012 1:09:00 PM

Page 1

Work Order ID: 82203

Parent Item: D4610-1

Parent Item Name: Doubler

Start Date: 3/26/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	191.1584		1.4526316			

12-3-08

Location

Loc Qty

Loc Code

MAT022

191.158421

117684

21.318421

120196

59.41

120605

110.43

120605

12

Work Order: 82203

Part Number: D4610-1

Page 1 of 1

•

X





Prototype

Rev	Date -	Change	Revised by	Approved
A		New Issue	KJJ/JLM	

D4610-1 DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

A		NEW ISSUE		RF		12.02.24			
REV.		DESCRIPTION				BY		DATE	
DESIGN		RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		RF							
CHECKED				DRAWING NO.				REV. A	
MFG. APPR.				D4610				SHEET 1 OF 4	
APPROVED				TITLE				SCALE	
DE APPR.				DOUBLER				NTS	
DATE		12.02.24		<p><small>COPYRIGHT © 2012 BY DART AEROSPACE LTD</small></p> <p><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small></p>					

RELEASED
2012-03-21
PER ECN 12-545

480003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries